

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021261**Date Inspected:** 04-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhu Zhang Hai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

OBG Segment 9AW-9BW

Shielded Metal Arc Welding (SMAW) in the 4G position of Deck Panel repair area, weld joint OBW9-003 as per repair report # B-WR-13911. The welder is identified as 37723. ZPMC CWI is identified as Zhang Hai Tao. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G(4F)-FCM-Repair-1. See attached photograph Pic_001

OBG Segment 9AW-9BW

Shielded Metal Arc Welding (SMAW) in the 4G position of Counterweight side Edge Panel to Side Panel hold back area, weld joint 9AW-CA055-006 & 9BW-CA59-002. The welder is identified as 045246. ZPMC Quality Control (QC) is identified as Zhu Zhang Hai. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1. See attached photograph Pic_002

OBG Segment 9AW

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Shielded Metal Arc Welding (SMAW) in the 3G position of Counterweight side Edge Panel weld repair area as per Repair Report # B-WR-13909, weld joint OBW9-001. The welder is identified as 045246. ZPMC Quality Control (QC) is identified as Zhu Zhang Hai. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G(3F)-FCM-Repair-1.

OBG Segment 9AW-9BW

Shielded Metal Arc Welding (SMAW) in the 1G position of Deck Panel repair area, weld joint OBW9-002 as per repair report # B-WR-13910. The welder is identified as 45221. ZPMC CWI is identified as Zhang Hai Tao. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G(1F)-FCM-Repair-1.

OBG Segment 9AW

During in process visual inspection of 9AW, This QA Inspector observed ZPMC NDT personnel Mr. Wang Wei performing Magnetic Particle Testing (MT) on Side Panel 'T' Ribs holdback area of Crossbeam side connecting end to 8CW.

OBG Segment 8CW

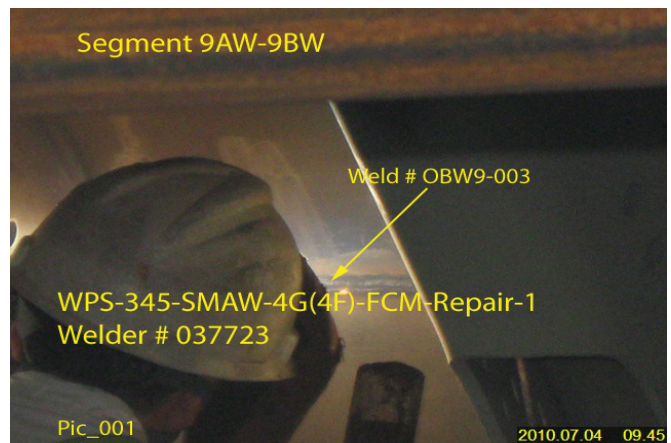
This QA inspector performed Magnetic Particle Testing (MT) approximately 15% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as 8BW-8CW RETRO Plate as per notification # 06122 item # 1

The weld designations reviewed are as follows:

RETRO-G-01-8CW-A1-026, 027, 033 and 034

RETRO-G-01-8CW-A2-031, 032, 037 and 038

RETRO-G-01-8CW-A3-026, 027, 035 and 036



Summary of Conversations:

No relevant conversations reported on this date.

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Gade,Ramesh	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
